Date: Monday, 16/03/2009 2:01:02 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46518
Estimate Number : 10827
P.O. Number :
This Issue : 16/03/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL /MED FAB
Previous Run : 43857
Written By :
Checked & Approved By : JW 09.03.16
Comment : Est B 00.05.19 Added inspect level 8 EC
Est C 06.04.26 Water jet EC
Est Rev:D Now M6061-T6 06-06-23 JLM
Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Drawing Name : SADDLE SPACER
Part Number : D2877
Drawing Number : D2877 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 10/04/2009 **Qty:** 40 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet

Comment: Qty.: 0.0637 sf(s)/Unit Total : 2.5494 sf(s)
Material: 6061-T6 (QQ-A-250/8) 0.125" Thick
Batch: 109058
ml 09 03 29 (40)

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2877
Dwg Rev: B
Prog Rev: B

2- deburr
ml 09 03 29 (40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 29 (40)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

counts
S 09/03/30 (x40)

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary
u/40

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 2:01:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE SPACER

Job Number: 46518 **Part Number:** D2877

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

40

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 FL 09/03/30

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 09-03-30 X40

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ ST53 SS 09/03/31

9.0	QC21	FINAL INSPECTION/W/O RELEASE

09/04/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

MF 09-03-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46518
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.98	+/-0.030	0.982	✓		VERN	
R0.06	+/-0.030	0.06	✓		R.G	
R0.30	+/-0.030	0.30	✓		R.G	
1.00	+/-0.030	0.994	✓		VERN	
0.250	+0.030/-0.000	0.250	✓		VERN	
Ø0.257	+0.005/-0.000	0.257	✓		VERN	
0.125 thick	+/-0.005	0.126	✓		VERN	

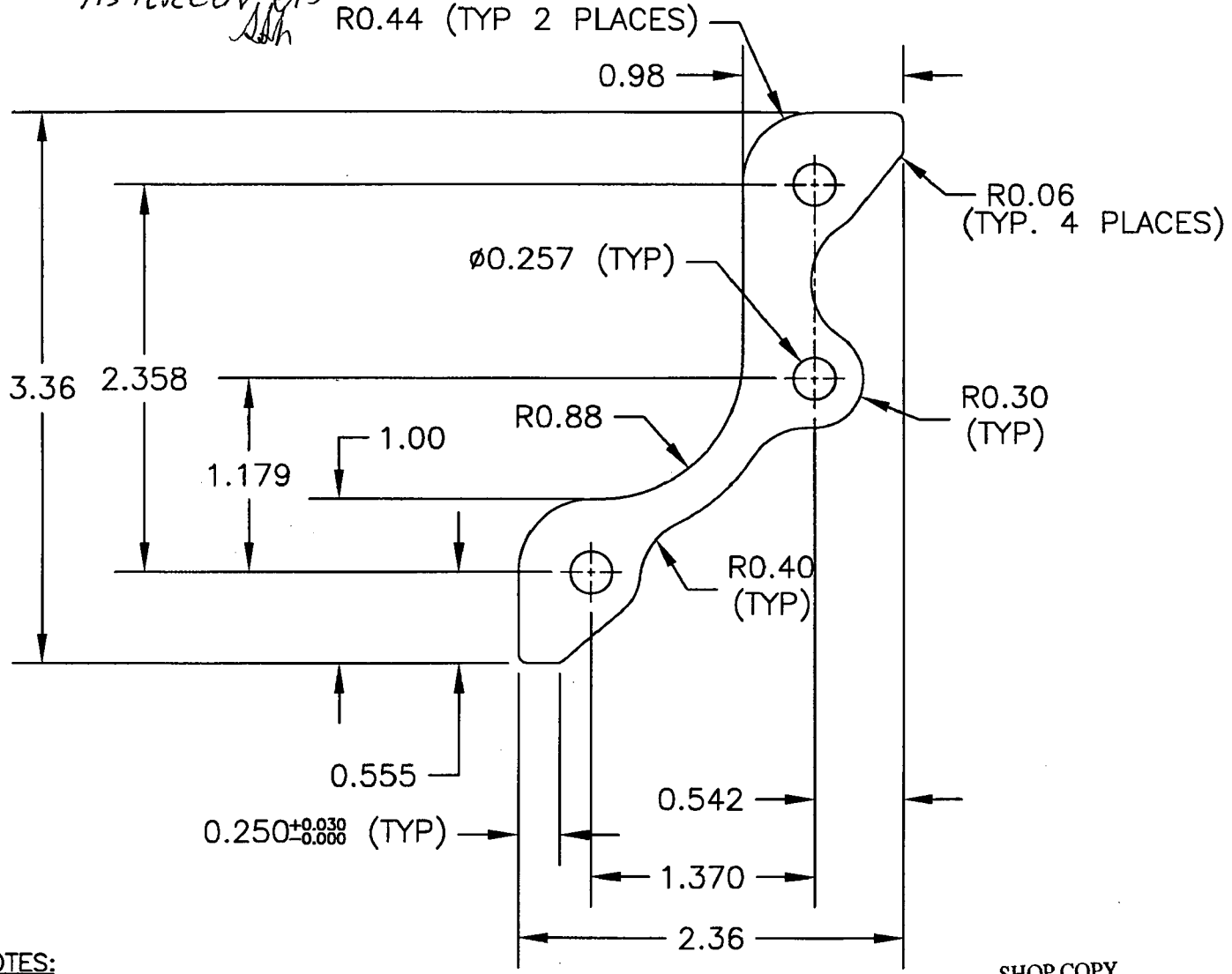
Measured by:	M. M	Audited by:	S	Prototype Approval:	N/A
Date:	09.03.29	Date:	07/03/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1

A	99.02.23	NEW ISSUE
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE

RELEASED
06.06.21.
AS PER ECN 813



NOTES:

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 405518

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